

Date: Thursday, 11/09/2008 10:43:23 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	02.500 SUPPORT
Job Number :	41986		
Estimate Number :	11058		
P.O. Number :		Part Number :	D28921
This Issue :	11/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2892 REV A
First Issue :	11	Project Number :	N/A
Previous Run :	38199	Drawing Revision :	A
		Material :	
Written By :		Due Date :	22/09/2008
Checked & Approved By :	JL 08.9.11	Qty:	20
Comment :	Est. C 02.11.26 Added P/O KJ Est. D 08.03.19 Re-format EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DSK077	D2892-1 TURNING DETAIL
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)

D2892-1 TURNING DETAIL

Batch: 38203

J.L 08/09/25

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS

Machine as per Folio FA082

Tumble & Deburr

J.L 08/09/25

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/09/25

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JIP 08/09/28

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
 400 OF
 11:30

M-L 08/09/29

(20X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/09/2008 10:43:24 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.500 SUPPORT

Job Number: 41986

Part Number: D28921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gs



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-24

(20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml

08 09 30

(20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41984
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.131	.131	.132	.132	.132
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.048	.049	.049	.050	.051
AD	0.115	0.135		.125	.125	.125	.125	.125
AE	0.240	0.260		.252	.253	.252	.252	.253
AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.134	1.132	1.133	1.136	1.139
AI	0.454	0.474		.459	.459	.464	.464	.464
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.259	.259	.259	.259	.259
AM	1.663	1.683		1.676	1.676	1.674	1.674	1.675
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: JL	Date: 08/09/25
Audited by: JIP	Date: 08/09/28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 41986
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.049	.049	.049	.052	.052
AD	0.115	0.135		.125	.125	.125	.125	.125
AE	0.240	0.260		.251	.252	.251	.252	.253
AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.130	1.137	1.139	1.135	1.140
AI	0.454	0.474		.464	.465	.465	.466	.466
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.259	.259	.259	.259	.259
AM	1.663	1.683		1.675	1.676	1.675	1.676	1.676
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L	Date: 08/09/25
Audited by: JTP	Date: 08/09/28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 41980
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.051	.050	.052	.052	.050
AD	0.115	0.135		.126	.126	.126	.125	.126
AE	0.240	0.260		.254	.254	.254	.254	.254
AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.134	1.135	1.137	1.138	1.138
AI	0.454	0.474		.466	.466	.464	.464	.464
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.259	.259	.259	.259	.259
AM	1.663	1.683		1.676	1.675	1.676	1.676	1.673
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L	Date: 08/09/26
Audited by: DIP	Date: 08/09/28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 419810
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

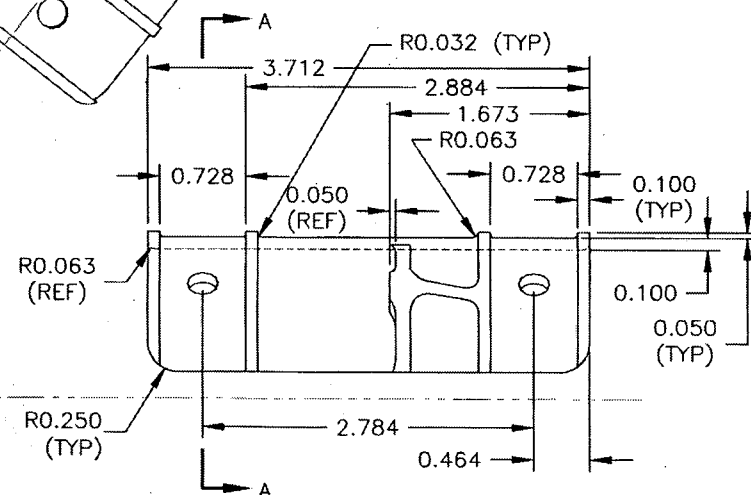
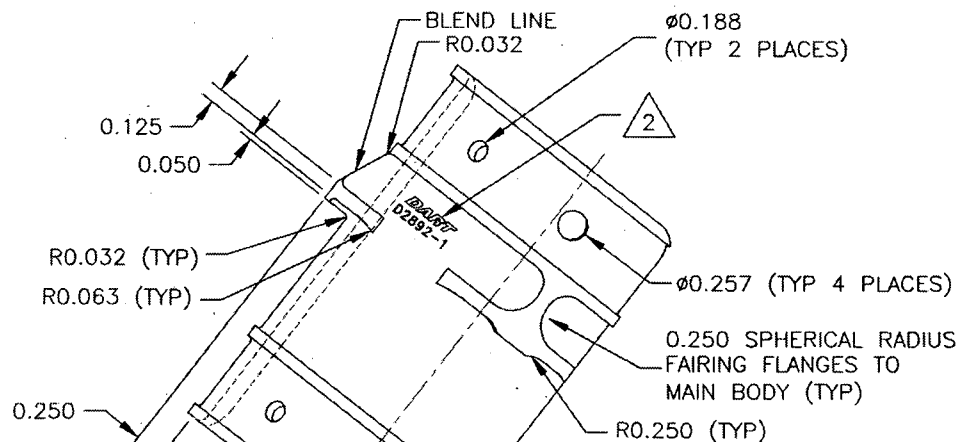
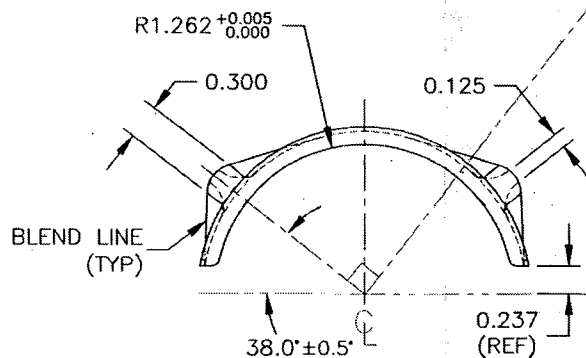
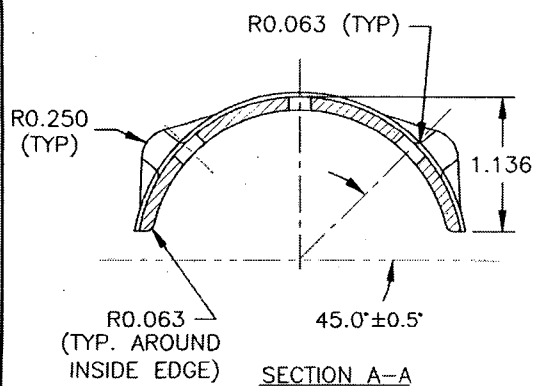
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.052	.051	.052	.052	.052
AD	0.115	0.135		.126	.126	.126	.126	.126
AE	0.240	0.260		.253	.254	.254	.252	.253
AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.140	1.134	1.140	1.137	1.131
AI	0.454	0.474		.464	.465	.465	.464	.464
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.258	.258	.258	.258	.258
AM	1.663	1.683		1.673	1.674	1.674	1.673	1.674
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L.	Date: 08/09/26
Audited by: DJP	Date: 08/09/28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

D2892-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



A	00.11.17	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2892
DATE		TITLE 00.11.17 Ø2.500 SUPPORT

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REV. A
SHEET 1 OF 1
SCALE
1:1